

NCR-19-7386.



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A93-3303-02-3
Job Sheet 199087



Deviation
19gn

Part No: RBE350A93-3303-02-3

Job Qty: 20 pcs

Part Name: Extractor



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/12/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 9/3/19

Description:

Type: Stock

Note: RBE350A93-3303-02 REV 5 IPP REV A 18-01-17 NEW ISSUE JFC VERIFIED DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	NV5000 - 1	20 pcs	9/3/19	9/3/19	1.00	5.00	NV5000 - 1		ALA.
							NV5000 - 2		
130	QC 2	20 pcs	9/3/19	9/3/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		ALA. / 23
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		19-08-15
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

19/08/19



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S205448



Part: RBE350A93-3303-02-3

Job No: 199087

Serial No/Batch: S205448

Revision: 5

Inspector:

Exp Date:

Instructions:

Date: 08/14/19

140 QC 8	20 pcs	9/3/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	HML 19/08/15
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
170 Outsource - 12 - Black Oxide	20 pcs	9/3/19		GRO002-VC	10
180 Packaging 2-1 - Receive - B4B	20 pcs	9/3/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	JP AUG 26 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
190 QC 6	20 pcs	9/3/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	DAS
					QC 6 - 40	81
					QC 6 - 81	9-89
200 Packaging 3-1 - Stock - B4B	20 pcs	9/3/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
210 QC 21 - SA	20 pcs	9/3/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

AUG 27 2019

DAS
28
9-89

Part Op 120 - NV5000-1 (MORI SEIKI VERTICAL MACHINE #1) 1-Machine as per folio FB740 FOLIO REV: AA DWG
 Descriptions: REV: S 2-Debur
 130 - (QC2- Inspect parts off machine FAI/FAIB)
 140 - (QC8- Inspect parts - second check)
 170 - Issue P/O to Groupe Altech; PO 44272 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of
 Conformity is required
 180 - (Receive & Inspect for Damage & Mat'l Certs)
 190 - (QC6- All purchased or subcontracted products)

200 - (Identify as per dwg & Stock Location: _____)
210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M1018B1.000X01.750	1010-1025 Steel Bar 1.000 X 1.750	6.4000 ft (.32 ea)	120-NV5000 - 1	S159395

cut at
Bar.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-NV5000 - 1	M1018B1.000X01.750	6	6	0

Part Specifications

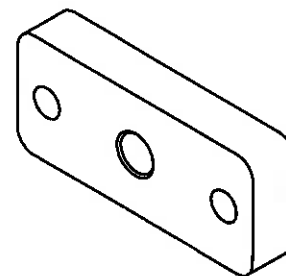
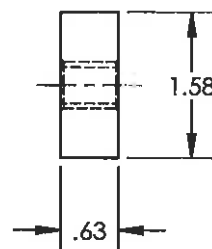
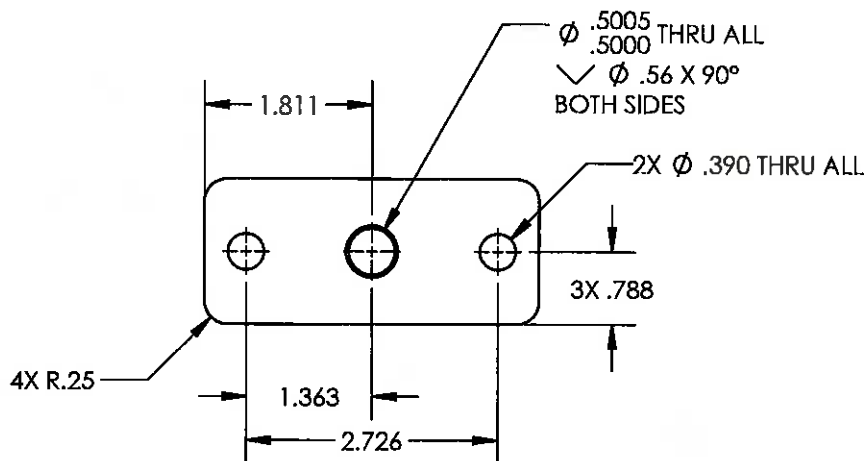
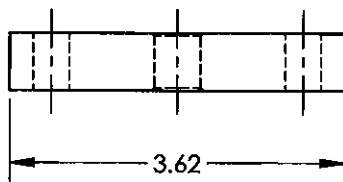
Specifications could not be found.

Plex 8/12/19 1:50 PM Dart.lajeunesse.marie

~~19750~~

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-3 CH'D HOLES FROM Ø.413 AND ADDED R.25 TO CORNERS.	12/4/2008	WP	DW
3		-3 CH'D DIMS WAS Ø.500 IS LIMITS Ø.5000 - .5005, WAS .630 IS (.625).	3/13/2014	DPD	GE
4	15-0132	-3 CH'D MATERIAL WAS 1018 IS A36/1018/1020.	6/10/2015	RJC	JAG
5	17-0169	-3 CH'D MAT'L WAS A36/1018/1020 IS A36/1018/1020 HR. ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D.	7/13/2017	DPD	JAG



SHOP COPY
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WITHOUT NOTICE
WORK ORDER
199087 190709

③

EXTRACTOR

DART AEROSPACE	
TITLE T/R BODY EXTRACTOR TOOL	
DWG NO. RBE350A93-3303-02-3	REV 5
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± 5°
SPEC QMSI-6.2.2, B.O. REV D	.X ± .1 SURFACES = 125/✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: RJC 07/13/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/21/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/24/2017	USED ON MODEL
APPROVED: JAG 07/26/2017	EUROCOPTER AS350A
SCALE 1:2	DATE 10/27/2008 SHEET 3 OF 5



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044272



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044272
PO Date: 8/15/19
Due Date: 8/23/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

E-MAILED
2019-08-16

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	197183	RB6872882-1	Adjusting Screw -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	8/23/19	4 pcs	0 pcs	4 pcs	\$2.35/pcs	\$9.40

4 X AUG 22 2019

5199376



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PURCHASE ORDER

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Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	196746	RBW109-3130-53-113-3	Pin -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MIL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	8/23/19	12 pcs	0 pcs	12 pcs	\$2.35/pcs	\$28.20
							12 X	AUG 22 2019			
											5203982
3	197461	RBE350A93-3317-20	Tail Rotor Hub Insert Tool Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/23/19	20 pcs	0 pcs	20 pcs	\$5.41/pcs	\$108.20
							20 X	AUG 22 2019			
											5200134
4	199087	RBE350A93-3303-02-3	Extractor Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/23/19	19 pcs	0 pcs	19 pcs	\$2.65/pcs	\$50.35
							19 X	AUG 22 2019			
											5205448



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PURCHASE ORDER

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Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	198324	RBW6521A00138-W142AH-3T-3	Top Brace -Issue P/O: _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	8/23/19	4 pcs	0 pcs	4 pcs	\$3.70/pcs	\$14.80
6	199075	RBST2120-15	Locating Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/23/19	5 pcs	0 pcs	5 pcs	\$2.35/pcs	\$11.75
7	199077	RBST2120-9	Pin Outsource12 (Outside Processing - Black Oxide) Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/23/19	5 pcs	0 pcs	5 pcs	\$0.95/pcs	\$4.75

4 X

AUG 22 2019

5204894

5 X

AUG 22 2019

5205486

5 X

AUG 22 2019

5205338



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PURCHASE ORDER

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Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	197189	RB6872882-9	Handle Weldment Outside Processing - Black Oxide -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	8/23/19	3 pcs	0 pcs	3 pcs	\$0.95/pcs	\$2.85

3 X AUG 22 2019

5 205327

Grand Total: \$230.30

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/16/19 9:01 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(021617-2)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

021617 - 2

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expedition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
23-Aug-2019		Jigar Patel		POHB044272				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir / Back Order
4	RBE350A93-3303-02-3 Rev.	RBE350A93-3303-02-3 01-BLACK OXIDE, MIL-C-13942C, CLASS 1	BLACK-OXIDE CH	19	19	0	0	0

RECEIVED
 AUG 26 2019
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

1 BOX

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

JAY

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

Entered: 22 Date: Oct 3/14



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 9-7386

Route update only

Job: <u>197450</u>		DISPOSITION		DEPARTMENT/PROCESS			
Part No. <u>RRF350A93-3308-02-3</u>		Rework ☐ Scrap ☐ Use-as-is ☒		Skid-tube ☐ Machining ☒ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier Quality ☐
Date: <u>19-08-14</u>		Sequence #: <u>120</u>		QTY Affected: <u>2 19</u>		MRB (OSI042)	
Description Work Order Deviation				Disposition			
<u>.500" hole dim is .501" to .5002 taper</u> <u>- supposed to be .500" - .5005"</u>				<u>THIS DEVIATION IS ACCEPTABLE TO</u> <u>USE AS IS</u> <u>FIT, FORM AND FUNCTION WILL</u> <u>BE AS ORIGINALLY INTENDED</u>			
				Completed By <u>ALA 19/08/14</u> Lead hand / Supervisor <u>B. 19-08-15</u> QA Coordinator <u>DAS 68</u> <u>9-89</u> <u>AUG 15 2019</u>			
Root Cause		FAULT CATEGORY					
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☒ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ ☒ Drill Holes <u>Ream taper</u> Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					
		Other/Details:					